

Friday, 11/18/2005 3:03:36 PM

Linda Lacello

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 24843 -1
 Estimate Number : 10313
 P.O. Number : NIA Part Number : D26483
 This Issue : 11/18/2005 S.O. No. : NIA Drawing Number : D2648 REV D
 Prsht Rev. : NC Project Number : NIA
 First Issue : NIA Type : PURCHASED PARTS Drawing Revision : D
 Previous Run : 23978 Material : NIA
 Due Date : 12/20/2005 Qty: 400 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USEC
 Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 146

Email or ship DXF file to vendor

Make per Drawing D2648-1

Material release note required

05.48-22

2.0 D26483F Wearpad


 Comment: Qty.: 1.0000 Each(s)/Unit Total: 400.0000 Each(s)
 WEARPAD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

402

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.01.05

402

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

NIA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 24843

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 06/01/10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R560Hardcoat M19442

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

CPL 06-01-31 (200)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/01/31 (200)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/01/31 (200)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21 200

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 02 21 200

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

MA 06 02 21 200

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

S4C 06/02/22 (200) 06/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024843
Project Name : D2648-3
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D2648-3
Description : Wearpad
Manufactured : Yes
Amount Req'd : 400
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

(13)



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waikato
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: S210/22495

CUSTOMER	Wilkinson	P50323 DI001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER D/N	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL D/N	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)						
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100				x1000										x10000		x100		180°			G.L.=	HRB
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460387-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

PA: 227181
INV: 551031MD009

706-07-05

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=45	(A)=10mm x 10mm (B)=7.5mm x 10mm	(A)=C+Mn/8 (B)=C+Mn/5+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/8+Si/24 (D)=
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 x So (F)=8"	(B)=90 (D)=(r0+r90+2r45)/4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
QC METALLURGIST

POST 146, 245, 267

1696 m

YIEN MAU CORP.

INVOICE NO. :
COMMODITY :

FORM 471
PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304/304 (SIC)
FINISH WITH 140 MIC. FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.
AISI 304
INTEGRIS METALS LTD

SPECIFICATION :
CUSTOMER :

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

工廠:高雄馬路竹脚順安路345號
345, SHUN AN RD, LU CHU HSANG
KAOHSUNG TAIWAN R.O.C.
TEL:877897895 FAX:877897808
CERTIFICATE NO:9908222
DATE OF ISSUE:08/18/2004

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
16GA48"X120" (7425-8881)	1	1,473	3,247	YU132553	34S21644B-4	285	808	58	81	150	3.9	48	115	24	4	807	1827	3.2
12GA48"X120" (7425-8310)	1	1,465	3,186	YU228940	34S21939B-5	280	800	57	80	158	4.2	48	118	24	8	820	1828	2.8
20GA48"X120" (7425-2894)	1	1,457	3,212	YU228245	35S22525A-3	285	835	54	82	159	4.6	48	126	30	3	815	1827	2.5
18GA48"X120" (7425-3629)	1	1,435	3,164	YU131855	35S22522A-2	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
18GA48"X120" (7425-3629)	1	1,435	3,164	YU131855	35S22522A-3	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
18GA48"X120" (7425-3009)	1	1,414	3,117	YU131855	35S22522A-4	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
18GA48"X120" (7425-8988)	1	1,480	3,283	YU228628	35S23009A-4	277	855	54	77	145	4	47	112	28	4	821	1815	2.9
16GA48"X120" (7425-8977)	1	1,437	3,168	YU229031	35S22903C-5	298	800	53	82	160	4.2	49	114	32	5	810	1813	1.7
16GA48"X120" (7425-8409)	1	1,430	3,153	YU132890	35S23091B-11	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
16GA48"X120" (7425-8409)	1	1,430	3,153	YU132890	35S23091B-9	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
16GA48"X144" (7427-3543)	1	1,391	3,087	YU132890	35S23081B-12	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
12GA48"X120" (7427-3893)	1	1,465	3,230	YU228945	35S23007A-12	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120"	1	1,371	3,023	YU228945	35S23007A-13	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120"	1	1,375	3,031	YU228945	35S23007A-14	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120" (7427-4137)	1	1,375	3,031	YU228945	35S23007A-15	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120"	1	1,423	3,137	YU132889	35S23083A-11	294	846	53	82	161	5.2	51	115	31	3	802	1823	2.8
16		22,836	50,346															

NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Band test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A430,
A362B, ASTM SA340, QCS788D.

YIEN MAU CORP.

Lin Kim Hsing
Manager of Quality Assurance Section

16ga 304 #4 S

1004 186, 184

1416

